

Work Order ID 149537

Monday, July 25, 2016 2:27:18 PM

149537

Page 1

Item ID: D2369-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Locator Plate

Start Date: 7/21/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/25/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

DAS
21Date: **AUG 02 2016**

Tooling:

Date:

Run Start ***NR1***

QC:

9-89

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2369

B

100

0.03

100

FLOW WATER JET

Waterjet

Memo

0.04

FLOW CNC Waterjet

1-Cut as per Dwg D2369

Dwg Rev: **B**Prog Rev: **B**

2-Deburr if necessary

(2)**ac 12/09/11**

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(3)**ac 12/09/11**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐ _____							

Work Order ID 149537

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149537

Page 2

Item ID: D2369-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Locator Plate

Start Date: 7/21/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/25/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 16 9-89
120						x2			16/09/12
QC	Memo	0.01							
Quality Control									
130	Identify as per dwg & Stock Location: <u>8225B</u>	0.00							DAS 6 9-89
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.03							
Quality Control									

DAS
21
9-89

SEP 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
3rd 01 20-9 2nd 19 20-9									
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

Monday, July 25, 2016 2:27:17 PM

Page 1

Work Order ID: 149537

149537

Parent Item: D2369-1

D2369-1

Parent Item Name: Locator Plate

Start Date: 7/21/2016

Required Date: 7/25/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev A Removed from 9 Digit 05-12-05 JLM
IPP Rev:B now water jet 07-12-11 DD IPP REV:C
13.05.21 AS PER DWG REV.B VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased		No		100	sf	63.6137	1.354	2.850526			

M5052H32S 040

5052-H32 .040 Sheet

pc 16/09/11

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT022	46.6	
m134774	46.6	
MAT023	17.013684	
m132546	4.6	
m1342217	5.813684	
m134617	6.6	

135512

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

DART AEROSPACE LTD		Work Order: 149537
Description: Deck Plate Locator Bracket		Part Number: D2369-1
Inspection Dwg: D2369	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	.495	/		V: 02-02	
4.500	+/-0.010	4.495	/		Taper	
1.000	+/-0.010	—	—	—	—	
5.649	+/-0.010	5.650	/			
37.996	+/-0.010	37.996	/			
38.297	+/-0.010	38.297	/			
5.000	+/-0.010	5.003	/			
4.451	+/-0.010	4.446	/			
0.549	+/-0.010	.553	/			
Ø0.191	+0.005/-0.000	—	—	—	—	
Ø0.128	+0.005/-0.000	Ø.127	/			
39.000	+/-0.010	39.000	/			
38.544	+/-0.010	38.544	/			
0.940	+/-0.010	.939	/			

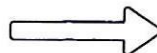
Measured by: ac	Audited by: DAS 16	Preliminary Approval:
Date: 16/09/11	Date: 9-89 16/09/12	Date:

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	13.06.27	Dimensions revised per Dwg Rev B	KJ	

5.000
4.500
0.500
0

Ø 0.128
6PL

D2369-1



FWD

D2369-1 DECK PLATE LOCATOR BRACKET

0.940
B

5.649
B

5.000
4.500
0.500
0

Ø 0.128
6PL

FWD



D2369-3

D2369-3 DECK PLATE LOCATOR BRACKET

0.940
B

5.649
B

R0.25 TYP

34.297

37.998

38.297

4.451

LABEL (D2364 UP)

0.549

35.000

38.544

39.000

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 149537

ML5

1608-02

R0.25 TYP

37.641

37.990

38.297

4.490

LABEL (D2344 UP)

0.664

38.344

38.528

39.000

RELEASED
2013-05-16

NOTES:

1) MATERIAL: 6061-T6 SHEET, 0.040" THICK PER QQ-A-250/11, AMS-QQ-A-250/11, AMS 4025, AMS 4027 OR ASTM B209 (REF: DART SPEC M8061T6S.040) OR 5052-H32 ALUMINUM SHEET, 0.040" THICK AS PER QQ-A-250/8 OR AMS-QQ-A-250/8 OR AMS 4016 OR ASTM B209 (REF: DART SPEC M5052H32S.040)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 0.27 lbs

8) PROFILE PER DRAWING FILE "D2369-1-REV.B.DXF" OR "D2369-3-REV.B.DXF"

B	DRAWING RE-FORMATTED TO NEW STANDARD, 5052-H32 WAS 5052-H34, ADD 6061-T6 MATERIAL OPTION (ZN A8-1) 0.940 WAS 1.000, 5.649 WAS 5.709 (ZN B6-1, ZN B7-1, ZN C6-1, ZN C7-1), REF CIR13-15	DB	13.03.22
A	NEW RELEASE	BW	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2369 REV. B SHEET 1 OF 1 SCALE DECK PLATE LOCATOR BRACKET NTS COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DRAWN	DB		
CHECKED	A.P.		
MFG. APPR.	al		
APPROVED	NO		
DE APPR.			
DATE	13.03.22		